

Date:  
User:Wednesday, 3/8/2006 10:38:37 AM  
Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BLOWER MOTOR SUPPORT	
<b>Job Number</b> :	26125			
<b>Estimate Number</b> :	12308			
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D34711	
<b>This Issue</b> :	3/8/2006	<b>Drawing Number</b> :	D3471 REV.A	
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A	
<b>First Issue</b> :	N/A	<b>Drawing Revision</b> :	A	
<b>Previous Run</b> :	N/A	<b>Material</b> :	N/A	
<b>Written By</b> :	<i>See comment below</i>		<b>Due Date</b> :	3/31/2006
<b>Checked &amp; Approved By</b> :	<i>06.03.08</i>		<b>Qty:</b>	10 Um: Each
<b>Comment</b> :	est rev A 06.03.02 New issue EC			

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 OUTSIDE SERVICE OUTSIDE SERVICES

**Comment:** Sub-Contracting OUTSIDE SERVICESIssue P/O: *00000768*

Email or Ship DXF file to vendor

Cut per Dwg D3471 flat pattern D3471-1F

possible supplier: GFI

Material release note required

2.0 D34711F BASE FLAT PATTERN

**Comment:** Qty.: 1.0000 sf(s)/Unit Total : *8.0000* sf(s)

SUPPORT FLAT PATTERN

3.0 PACKAGING 1 PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3471

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend as per dwg D3471

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:37 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26125

Part Number: D34711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06:03:29 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06:03:29 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST439

CZ06103/29 10

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06:03:30 (10)

Job Completion



06:03:29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

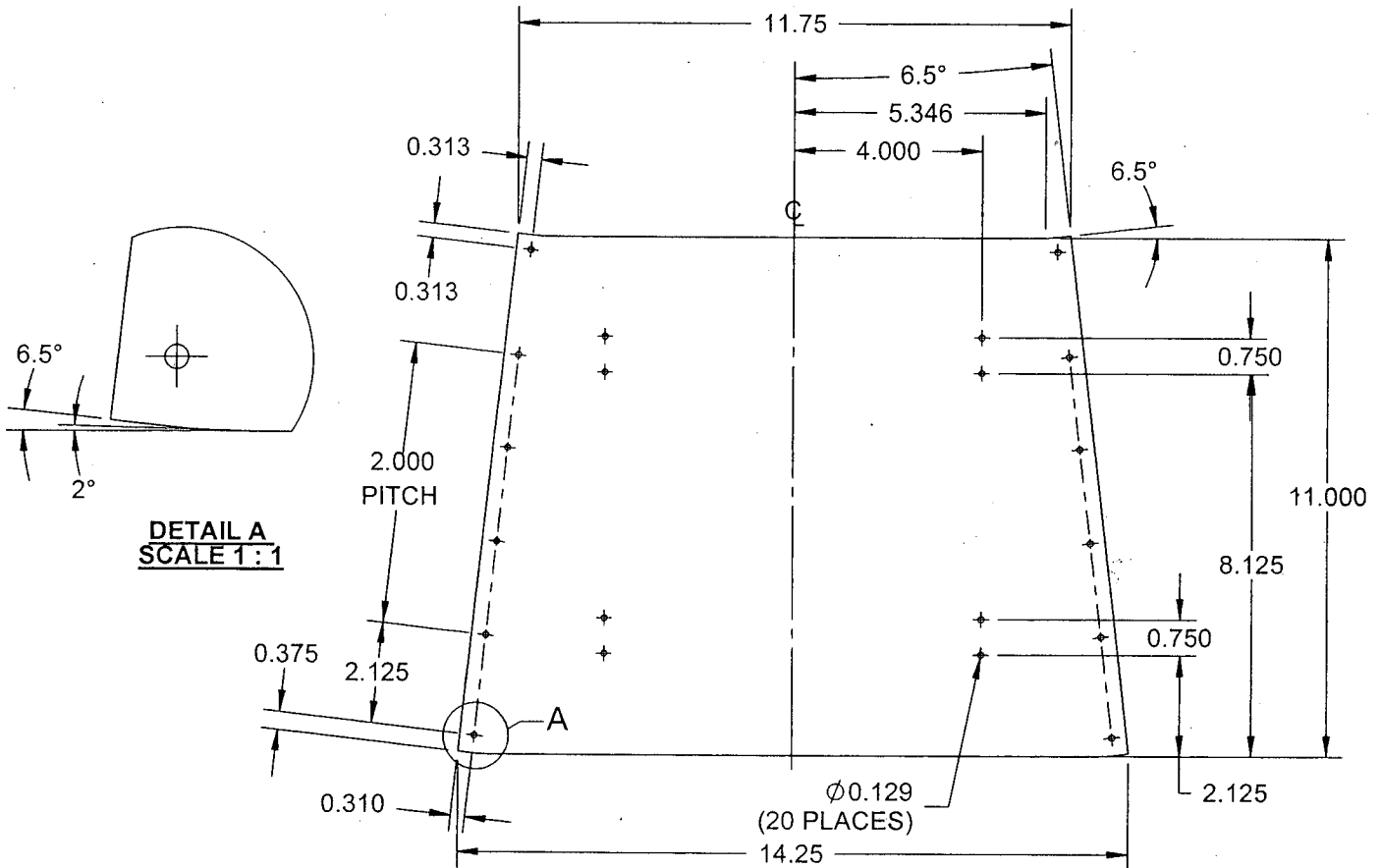
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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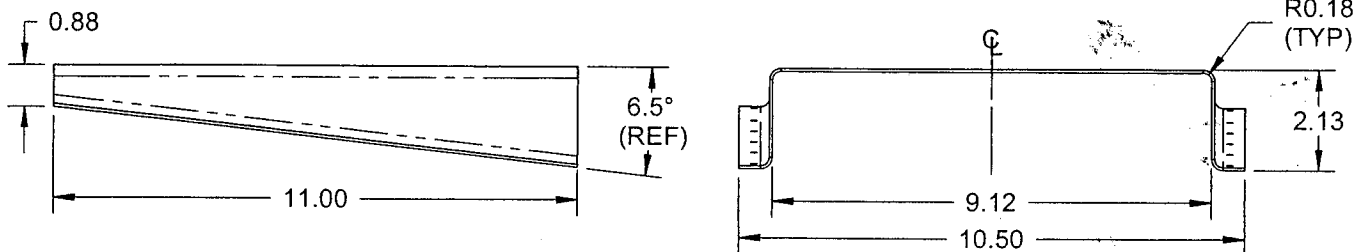
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 3 OF 5
DATE 05.12.21	TITLE BLOWER MOTOR SUPPORT		SCALE 1:4



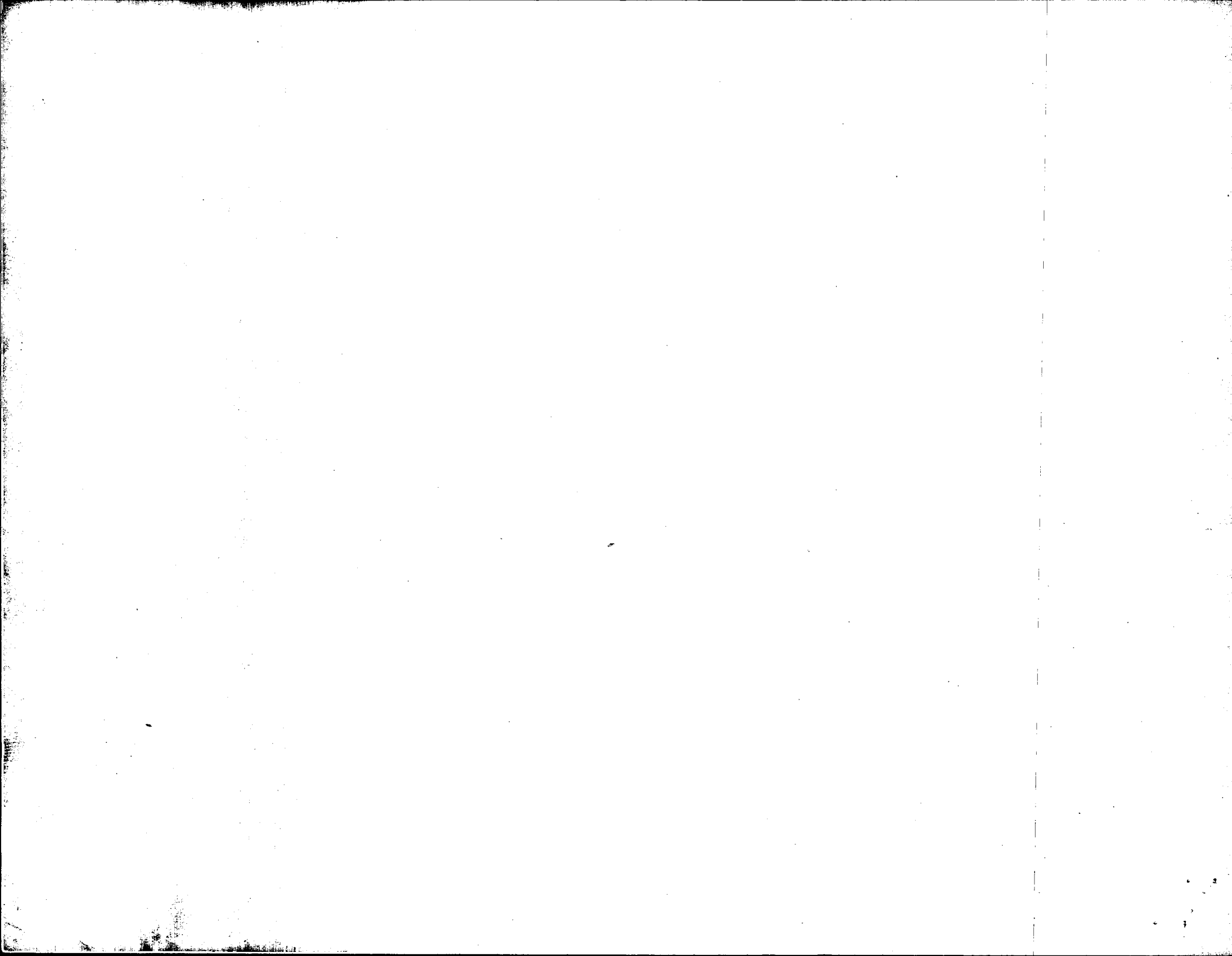
**D3471-1F BASE FLAT PATTERN**



**D3471-1 BASE BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



FAX 1 847 585 2500

CORUS ALUMINIUM

Corus Aluminij Walzprodukte G. .1  
 100331 D-56033 Koblenz



# INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: PAGE: 2 / 03  
 PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO  
 PRODUCTS USA-A DIVIS ORDER NO. MAN.: 83418  
 SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+GQ230/5  
 CUSTOMER PART NO.:  
 ITEM: 01 LOT: 102973 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA  
 QUANTITY: 344 DIMENSIONS: 0.040 x 48.00 x 144.00 INS

## Other tests:

Dimensional check: OK  
 Surface control: OK

## Normative references:

BESTELLNORM/SPECIFICATION/NORME  
 AMS 4041P+ASTM B 209-04+AMS-QQ-A-250/5A SEP1998

## Bend test:

L-direction

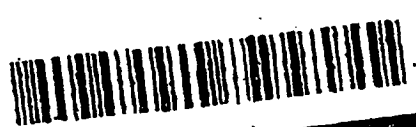
LT-direction OK

ST-direction





te G. .  
Koblenz



corus

CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE  
PAGE: 3 / 03

SERIAL-NO.:  
CORUS ALUMINIUM ROLLED  
PRODUCTS USA-A DIVIS  
CHAUMBURG, IL 60173  
ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO  
ORDER NO. MAN.: 83415  
SPEC.:  
AMS4041+BZ09+QQ250/5  
CUSTOMER PART NO.:

THAT THE WHOLE OF THE SUPPLIES DETAILED HEREON HAVE BEEN  
TESTED AND, UNLESS OTHERWISE STATED ABOVE, CONFORM IN ALL  
WITH THE REQUIREMENTS OF THE SPECIFICATION, CONTRACT OR ORDER.

res:

inZ, the 25.08.05 SW

G. Mattler  
Quality Assurance  
Corus Aluminium  
Walzprodukte GmbH  
Koblenz

MAR-23-2006 04:24 FROM:

TO:6049464153

Corus Aluminium-Walzprodukte G.m.b.H.  
Postfach 100331 · D-56033 Koblenz


  
**corus**

# INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: PAGE: 1 / 03  
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 PRODUCTS USA-A DIVIS ORDER NO. MAN.: 83415  
 SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+QQ250/5  
 CUSTOMER PART NO.:  
 ITEM: 01 LOT: 102973 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA  
 QUANTITY: 344 DIMENSIONS: 0.040 X 48.00 X 144.00 INS

## RESULTS:

### Mechanical properties:

Spec. No.	Y.S.	U.T.S.	El.
	KSI	KSI	%
Min. LT:	39,0	59,0	15,0
Max. LT:			
001	40,6	59,6	17,9
002	40,6	59,8	18,7
003	40,6	59,8	17,7
004	40,8	59,6	18,1

### Chemical composition: in % , remainder Al

ALLOY:	ALLOY CORE	ALLOY LINER	ALLOY LINER
CAST-NO.	2024	1230 4	1230 4
	5-08-2914	142166-1	142166-1
Si	0,028	0,12	0,12
Fe	0,123	0,26	0,26
Cu	4,326	0,002	0,002
Mn	0,634	0,010	0,010
Mg	1,436	0,003	0,003
Cr	0,001	0,001	0,001
Zn	0,011	0,005	0,005
Ti	0,0278	0,019	0,019
B	0,0006	0,002	0,002
Zr	0,0006		
Pb	0,0016	0,0011	0,0011
Ni	0,0059		

